

CLAIMS

1. A stranded conductor for forming an electric conductor, in particular a subconductor, for a winding of an electric machine with
 - an arrangement of several mutually parallel and/or twisted filaments, and
 - an insulation which surrounds the exterior circumference of the arrangement of filaments,characterized in that
the insulation is applied around the arrangement of the filaments by extrusion.
2. The stranded conductor according to claim 1, with the stranded conductor having a rectangular shape.
3. The stranded conductor according to claim 1 or 2, wherein the insulation satisfies the requirements for a subconductor insulation.
4. The stranded conductor according to one of the claims 1 to 3, wherein the insulation satisfies the requirements of a primary insulation at least on portions of the exterior circumference about the arrangement of filaments.
5. The stranded conductor according to one of the claims 1 to 4, wherein an elastic, extruded filling material which is made of a material different from that of the insulation and which, in particular, has an adjustable electrical conductivity, is introduced between the filaments.

6. The stranded conductor according to one of the claims 1 to 4, wherein the insulation applied by extrusion fills at least partially interstices between the plurality of filaments.
7. The stranded conductor according to one of the claims 1 to 6, wherein at least one material for increasing the thermal conductivity is introduced in the insulation according to one of the claims 1 to 6 and/or in the filling material according to claim 5.
8. The stranded conductor according to one of the claims 1 to 7, wherein an outer co-extruded conductive layer represents an exterior corona shielding, so that corona shielding at the ends can be eliminated.
9. Method for producing electric conductors, in particular subconductors for a winding of an electric machine by
 - arranging several mutually substantially parallel and/or twisted to form a stranded conductor, and
 - insulating the stranded conductor on its exterior circumference,characterized in that the insulation is applied by extrusion.
10. The method according to claim 9, wherein the stranded conductor has a rectangular shape.

11. The method according to claim 9 or 10, wherein the insulation satisfies the requirements for a subconductor insulation.
12. The method according to one of the claims 9 to 11, wherein the insulation satisfies the requirements for a primary insulation at least on portions of the exterior circumference about the arrangement of filaments.
13. The method according to one of the claims 9 to 12, wherein the cavity between the filaments is filled with an elastic, extruded filling material made of a material, which is different from the insulation and which, in particular, has an adjustable electrical conductivity.
14. The method according to one of the claims 9 to 12, wherein during the extrusion, the cavities between the filaments are at least partially filled with the insulation to be applied.
15. The method according to one of the claims 9 to 14, wherein at least one material for increasing the thermal conductivity is introduced in the insulation according to one of the claims 1 to 6 and/or in the filling material according to claim 5.
16. The method according to one of the claims 9 to 15, wherein an outer conducting layer operating as an exterior corona shielding is produced by co-extrusion, so that corona shielding at the ends can be eliminated.